

Date: Thursday, 12/14/2006 1:56:23 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE
Job Number	: 29957		
Estimate Number	: 11545		
P.O. Number	: <i>N/A</i>	Part Number	: D204635011
This Issue	: 12/14/2006 S.O. No. : <i>N/A</i>	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 29956	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 1/15/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	: Est Rev. 02.08.28 Removed QC5 KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and Type labels as per PPP D204-635-011 CHG004

*KS 06.12.18 ①*

2.0	29957A	SKIDTUBE
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Comment: Sub-Component Pick:

Qty	Part Number	Description	Batch
1	D204-635-041	Skidtube Assembly	<i>629957A</i>

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	<i>629615</i>

*EP 07/01/15*

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

*27/01/15*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RD Date: 07/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 1:56:24 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29957

Part Number: D204635011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-635-011

Location: \_\_\_\_\_

PPP Rev: B

*Handwritten signature and date: 27/01/15*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten date: 27/01/16*

Job Completion



*Handwritten note: U 07401.16*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 1:56:47 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE  
 Job Number : 29957A  
 Estimate Number : 11546  
 P.O. Number : N/A Part Number : D204635041  
 This Issue : 12/14/2006 S.O. No. : N/A Drawing Number : D2590 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C  
 Previous Run : 29956A Material : N/A  
 Due Date : 1/15/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25001190 Ext'n -1" Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2500-1-190 Skid Tube Extrusion 325858 Pmc 06-12-14 (1)

2.0 D2597 204 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2597 204 Web 25751 JB 06-12-18

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage Pm 06-12-15 (1)

2-Cut D2500-1-190 per Dwg D2590 .Deburr ends Pm 06-12-15 (1)

3-Drill pilot holes using drill jig DT 8149 & DT8711-1&-2 Pm 06-12-15 (1)

4-Acid etch and Alodine tube per QSI 005 4.1 Pm 06-12-15 (1)

5-Open holes to 0.500" as per Dwg D2590 without cutting fluid Pm 06-12-15 (1)

6-Countersink holes as per Dwg D2590 without cutting fluid Pm 06-12-15 (1)

7-Deburr and blow out all chips from inside of tube Pm 06-12-15 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29957A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description:

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch 29961

A/R Sikaflex-291

Sikaflex expire date: 01-02-01

Start Time: 16:00

Fin Time: 12-12-21

ST/JP 06-12-18 (1)

4.0

BENDING

BENDING MACHINE



6-12-21 EL/DP



Comment: BENDING MACHINE

Bend as per program D2590.C on CNC Bender

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



6-12-21 EL/DP



Comment: LANDING GEAR RESOURCE 1

1-Cut tubes as per Dwg. D2590

2-Deburr ends after cutting. Remove alodine from around holes

Pm 06-12-22 (1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-12-22

7.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2576-3 Step 229486

BE 06-12-22

8.0

D2579

Crossbolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total: 17.0000 Each(s)

Pick:

Qty Part Number Description Batch  
17 D2579 Spacers 229603

BE 06-12-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 12/14/2006 1:56:48 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29957A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required. *BE 06-12-22*

2-Weld step D2576 as per Dwg. D2590 and QSI 004

A/R

Aluminum Rod

*M 10/14/46*

*BE 06-12-22*

3-Weld crossbolt spacers D2579 as per Dwg. D2590 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

*M 10/14/46*

*BE 06-12-22*

4-Grind welds as per Dwg D2590 Grind flush ridge made from bending *Pm 07-01-02 ①*

5-Drill holes for wearplates using DT 8218 Open holes to 19/64", adjust stopper not to hit crosstubes. Deburr *Pm 07-01-02 ①*

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2590. Deburr holes *Pm 07-01-02 ①*

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr *Pm 07-01-02 ①*

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr *Pm 07-01-02 ①*

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*M 07/01/03 ①*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*M 07/01/03 ①*

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*M 102391*



*①*

Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

*M-A/YL*

*07/01/08*

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*M 07/01/11*



*①*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*(PTU)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-01-09	13.0	Upon the QC 3, 2 tiny pin holes in the weld around a x-bolt spacer were found.	QSI 042	Remove powder coat and weld pin holes AS per QSI 004. Grind flush. Have weld inspected. Re powder coat wh. le AS per QSI 005. 4.3.3.2.	BE 07-01-09		QSI 042	07-01-09

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29957A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	29485

15.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	29326

16.0

D25777

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-7	Wearplate	21607

17.0

D25941

Plug



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2594-1	Plug	29621

18.0

D25943

O-Ring



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2594-13	Plug	27168

yl 07/01/11 #

orins

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: SKIDTUBE

Job Number: 29957A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Cap 26351

20.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	ALS7-1032-130	Inserts	102475

21.0

AN960JD10L

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	AN960JD10L	<del>Inserts</del> Washer	102217

22.0

AN34A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-4A	Bolt	102832

23.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

15205

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2590. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date: 02/07

102672

yl

07/01/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   D   Date: 07/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 1:56:48 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29957A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2590 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 102672

Sikaflex expire date: 02/07

*JP*  
07/01/11

5-Wing Walk as per Dwg D2590 and QSI 005 4.4

Batch:

11103004 BS/Am

07/01/11 (1)

25.0

QC5

INSPECT WORK TO CURRENT STEP



FC 07-01-12 (1)



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)  
07/01/16

Job Completion



U 07/01/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2590	REV. C SHEET 1 OF 2
DATE 98.08.28		TITLE 204 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.28	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED  
98/09/11 BS

QTY	Part Number	Description
X	D2590-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2597	204 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
17	D2579	CROSS BOLT SPACER
10	D2594-1	PLUG
10	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-7	WEARSHOE
38	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
40	AN3-4A	BOLT
40	AN960JD10L	WASHER

# 08-28  
P 08-28

DEOS	
EFFECTIVE	9124 98/12/14

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 189.5 INCHES \*
- 3) INSERT D2597 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-204 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (38 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2597 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29957A

[illegible]

Diagram illustrating the installation of a bolt and washer on a cap. The diagram shows a cross-section of a cap with a bolt and washer being installed. The following labels and dimensions are provided:

- DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)
- #0.208
- AN3-4A BOLT (1)
- AN960JD10L WASHER (1) (2 PLACES)
- D2575 CAP
- SEAL WITH SIKAFLEX-241
- 0.40

Diagram of a wheel assembly with labels:

- D2579 SPACER
- D2597 WEB (REF)
- ALS7-1032-130 (REF) (TYP 38 PLACES)
- AFTER PERFORM
  1. CHA
  2. INS
  3. WEI
  4. C'B

SHOP COPY  
RETURN TO  
ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 24957A  
DATE 5:24

[illegible]

The diagram illustrates a cross-section of a bridge deck. Key dimensions and features include:

- Deck Width:** 11.5
- Top Flange Width:** 1.4
- Top Flange Thickness:** 1.0
- Distance between hole and tangent point:** 13.4
- Distance between hole and tangent point:** 6.5
- Distance between hole and tangent point:** 37.5
- Reinforcement:** #0.640
- Labels:** 4, 25.4, 11.5, 1.4, 1.0, 13.4, 6.5, 37.5, #0.640

38390-041 ASSEMBLY DETAIL

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

0.5

1.5

1.5

1.5

1.5

D

P

P

P

P

REFER TO DETAIL C

D2577-3

D2577-7

D2577-1

AN3-4A BOLT (1)

AN960J10L WASHER (1)

(38 PLACES)

8

RELEASED  
48/9/71 DS

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NO. 83

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number D204635041 / B29959 A

TEST WELDS REQUIRED

BASE METAL Alun WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	3G <input checked="" type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	5G <input checked="" type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	3F <input checked="" type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	4F <input checked="" type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into \_\_\_\_\_ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐

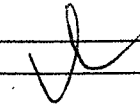
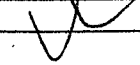
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/12/22 Qualifier David Savel

Date: Tuesday, 28/08/2007 12:40:11 PM  
User: Linda Lacelle

**Process Sheet**

<b>Customer</b> : CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> : UPDATE PAPERW. 634/635
<b>Job Number</b> : 34285	
<b>Estimate Number</b> : 10804	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : Z_CUSTOM
<b>This Issue</b> : 28/08/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : ECN 1023
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : N/A
<b>Previous Run</b> : 00015	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 04/09/2007 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> :	

**Additional Product**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

REMOVE FROM STK / ADD NEW PAPERWORK

EASA STC: EASA.IM.R.S.01303

B 32851, B 32854, B 32953, B 32951, B 32952, B 32212,  
D205-634-011 B 32613, 32618, B 32950, B 32615, B 32853, B 32213, B 32215

D205-634-041

D205-635-011 B 29278, B 29667, B 29955, B 29956, B 29957, B 29959


73 D205-635-041 B 21564, B 21821, B 22797, B 20000

D205-634-043

D205-634-045 B 12245

D205-634-011 B 33404

RETURN TO STK

 07/10/28

Date: Friday, 09/02/2007 9:59:35 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D205-635 / D204-635
Job Number : 30722	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z-CUSTOM ECN952/908
This Issue : 09/02/2007 S.O. No. : N/A	Drawing Number : UPDATE PAPERWORK
Print Rev. : NC	Project Number : N/A
First Issue : N/A Type : OVERHEAD	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : _____	Due Date : 16/02/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK

TC STC SH96-88, ISSUE 3 / PAA STC SR00563N4

D205-634-011

D205-634-041

D205-634-043

D205-634-045

D204-635-011

D204-635-041

Voix papier  
 avec ✓

7/4/27 SQ

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 RETURN TO STOCK

7/4/27 SQ